



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

D3121-21
Job Sheet 168661



Part No: D3121-21

Job Qty: 60 ea

Part Name: Bolt



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/21/17

Job Tracking No:

Due Date: 12/3/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV E IPP A 04.02.09 New issue KJ/DS IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea		12/2/17	0.00	0.00	Start Up Machining		mm 18/1/31
100	Hardinge	60 pcs		12/3/17	0.00	5.34	Hardinge		"
110	QC	60 pcs		12/3/17	0.00	0.00	QC2		"
120	QC	60 pcs		12/3/17	0.00	0.00	QC8		FK 18-2-2
130	Packaging	60 pcs		12/3/17	0.00	0.00	Packaging3		922
140	QC21-SA	60 Ea		12/3/17	0.00	0.00	QC21		DAS 21 FEB 05 2018

87018

Part Op Descriptions: 100 - 1-Turn D3121-21 2-Identify as D3121-21 3-Deburr break all sharp edges 0.005" to 0.010"

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303H0.500	303 Hex Bar .500	2.5020 ft (.0417 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303H0.500	3	21	0
m138 383 = 2.75				

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bolt	0.375Inches ± 0.010	0.385 0.365		
2	Bolt	0.050Inches + 0.010 - 0.000	0.060 0.050		
3	Bolt	0.080Inches ± 0.010	0.090 0.070		
5	Bolt	0.190Inches + 0.000 - 0.006	0.190 0.184		Major Diameter
6	Bolt	0.2146Inches + 0.0000 - 0.0017	0.2146 0.2129		Overwire

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

QA

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PART NO: D3121-21
Original Serial #: S037655
Revision:
Operation:
Change No:

Start up Operation 01/31/18
Job No: 168661

Bolt



S037655

DART
AEROSPACE

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work ☐
 scrap ☐
 as-is ☐
 oved ☐

Skid-tube ☐
 Machining ☐
 Thermoforming ☐
 Large Fab ☐

Cross tube ☐
 Small Fab ☐
 Finishing ☐
 Composite ☐

Water Jet ☐
 Prod. Eng. Coord. ☐
 Rec/Store/Packaging ☐
 Supplier ☐

Engineering ☐
 Quality ☐
 Other ☐

QTY Effective :

MRB (QSI042) Approval

Disposition

Completed By

Lead hand / Supervisor
 Approval Verification

QC / QA Coordinator
 Approval

FAULT CATEGORY

☐ Temperature/Cure
☐ Set-up
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Inspection Incomplete/Unqualified
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Instructions Incomplete/Unclear
☐ Drill Holes

☐ Power Loss/Surge
☐ Folio/Program
☐ Grain
☐ Weld
☐ Wrong Stock Pulled
☐ Out of Sequence
☐ Off-set
☐ Mislabeled
☐ Fit/Function
☐ Misaligned/off center

☐ Positioned Wrong
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Drawing
☐ Finish
☐ Misread
☐ Turning Sequence

Internal Transport ☐
 Tribal Knowledge ☐
 LOA ☐
 Substation ☐
 Past Expiry Date ☐
 Misidentified ☐

Product Improvement ☐
 Rushing ☐
 Product Improvement ☐
 Process Improvement ☐
 Manufacturing Process ☐
 Past Due ☐

Heat Treat ☐
 Wave/Twist in Tube ☐
 Marks/Chatter ☐

OTHER :